

Date: Thursday, 12/14/2006 3:39:43 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 29966	
Estimate Number : 10437	
P.O. Number : N/A	Part Number : D33191
This Issue : 12/14/2006 S.O. No. : N/A	Drawing Number : D3319 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 29172	Material : N/A
Written By : <u>JA</u>	Due Date : 12/21/2006 Qty: 6 Um: Each
Checked & Approved By : <u>JA 06/12/15</u>	
Comment : Est: B 05.10.14 Added step 9, dwg rev B KJ/EC Est Rev:C Now on Waterjet 06-10-26 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048
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Comment: Qty.: 0.6594 sf(s)/Unit Total : 3.9564 sf(s)

1010/1025/A21/6aA SHEET .048

Batch: m102287

ml 07/01/04

(6)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: B

Prog Rev: B

ml 07/01/04

(6)

2-Deburr if necessary

SAD 07/01/06

(6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07/01/04

(6)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/01/05

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

SAD 07/01/06

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 3:39:43 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 29966

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

2- Form flat on press using DT8776 block

SB 07/01/17 (6)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07/01/17 (6)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod

M102885

MF 07-01-19 (6)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/01/22 (6)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

YR 07/01/22 x 6

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ml 07/01/22

(x6)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 5382

07/01/22 (6) 07/01/22 (6) 07/01/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 12/14/2006 3:39:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 29966

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/24

Job Completion



4 070124

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

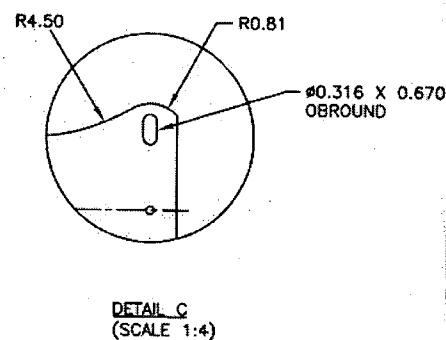
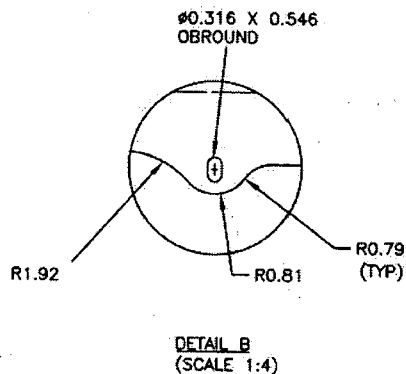
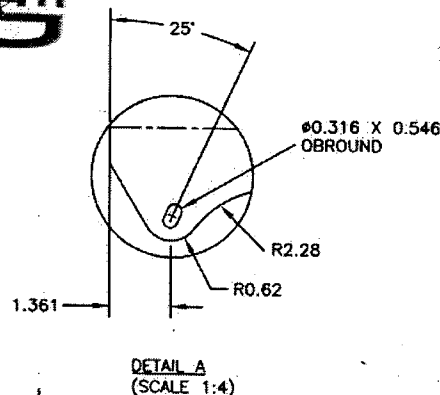
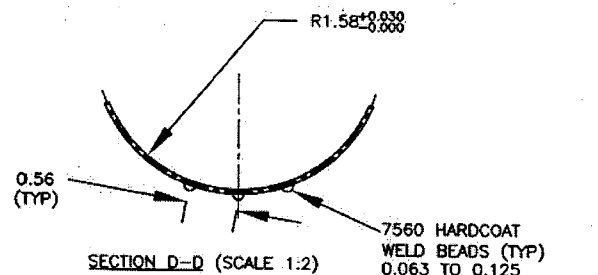
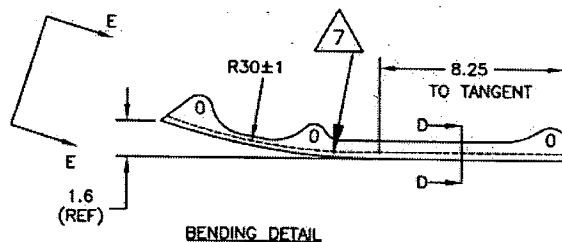
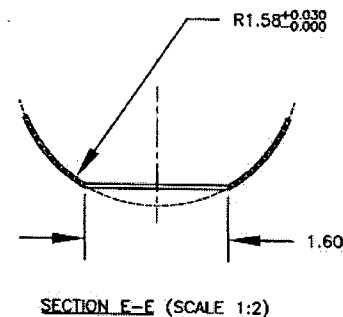
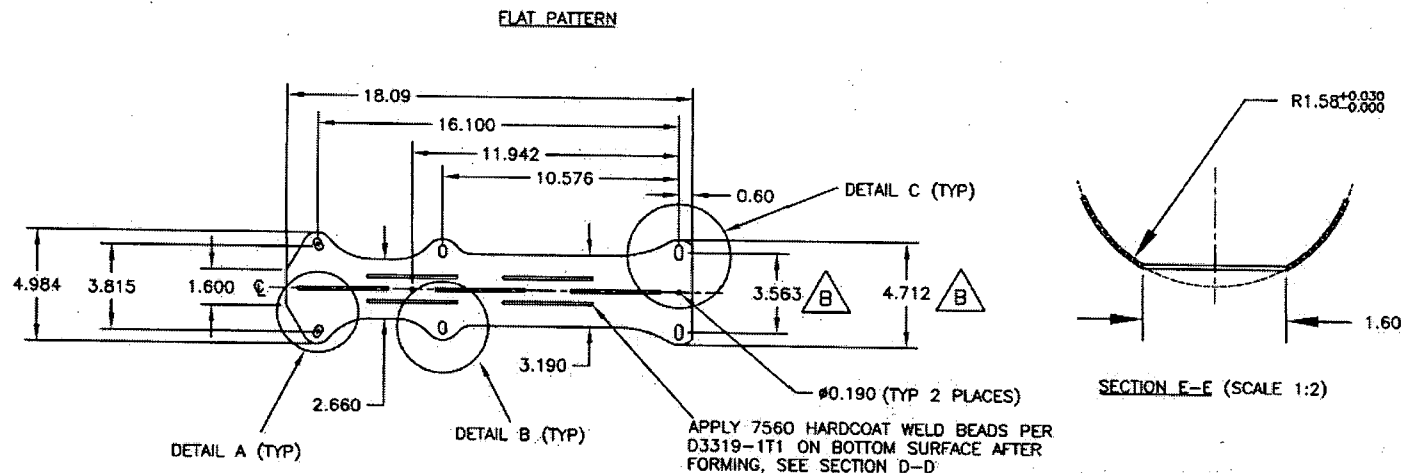
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**



**D3319-1 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
P41	P41	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1:8
A	DATE	REVISION
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7

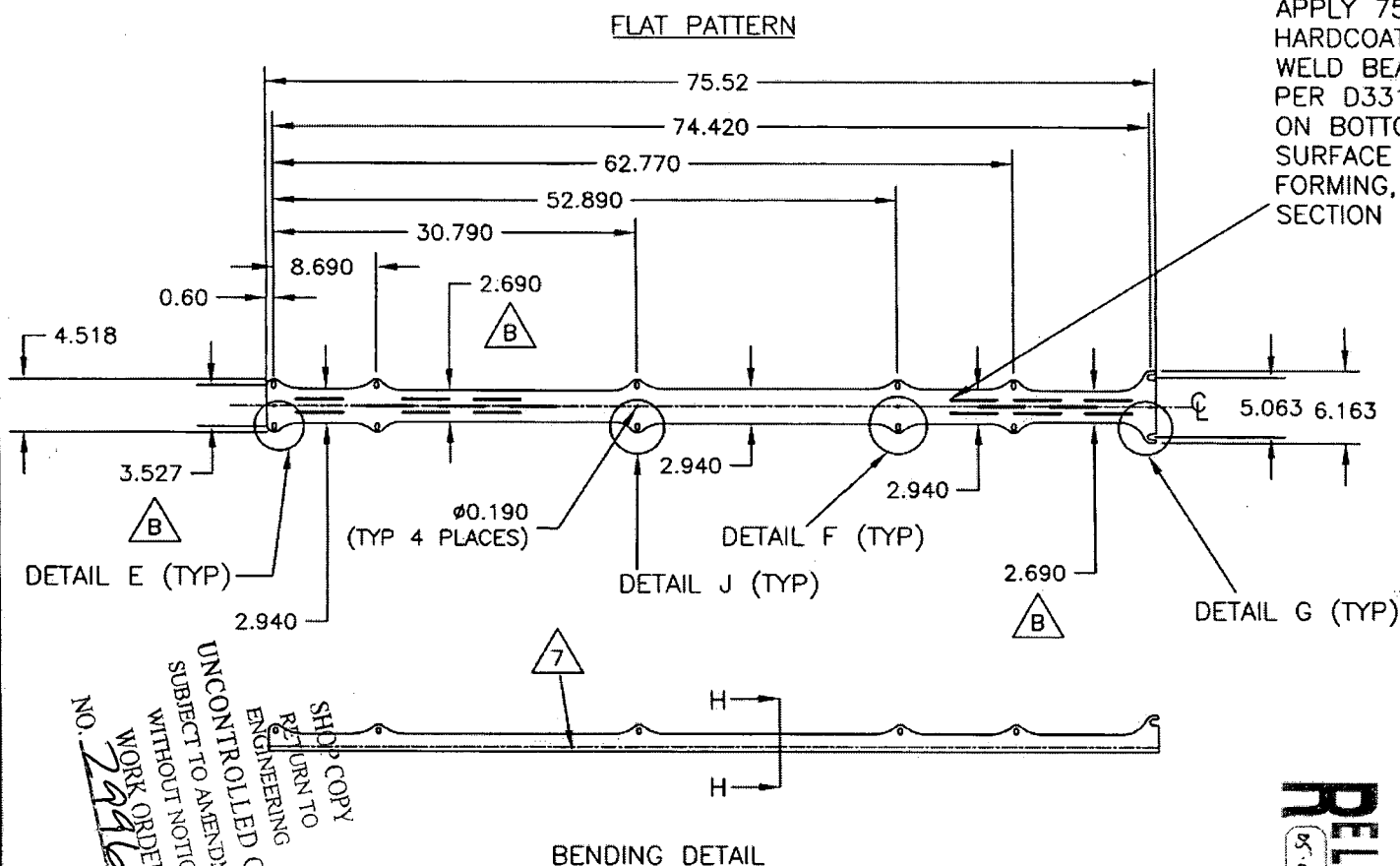
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WITHOUT NOTICE

RELEASED  
05-01-30

**DART**

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
		WEARPLATE		SHEET 2 OF 5
				SCALE 1:15

APPLY 7560  
HARDCOAT  
WELD BEADS  
PER D3319-3T1  
ON BOTTOM  
SURFACE AFTER  
FORMING, SEE  
SECTION H-H



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WORK ORDER  
NO. 29966

**RELEASED**  
05.07.30

# **D3319-3 WEARPLATE**

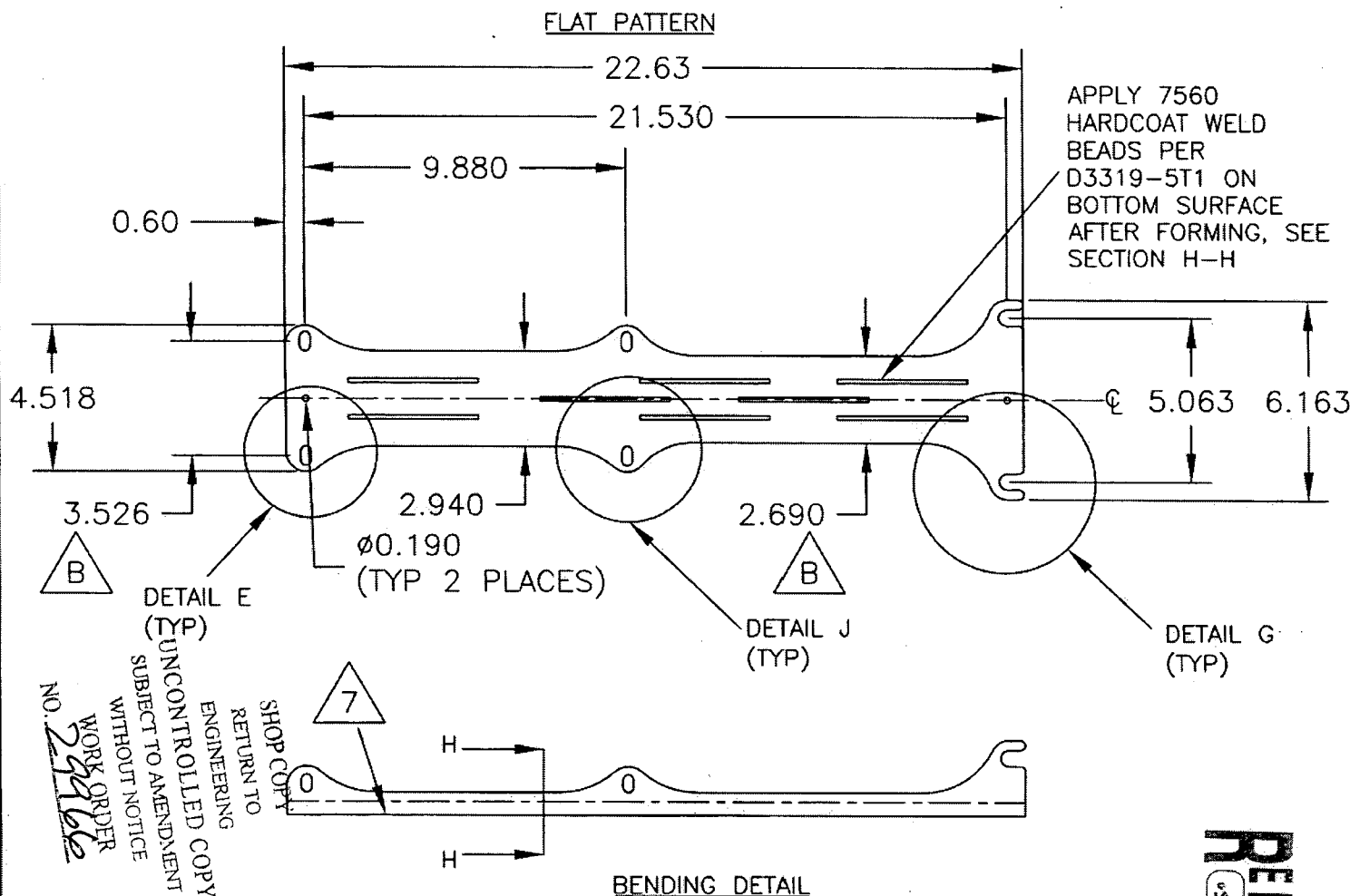
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



**RT AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DESIGN	D41	DRAWN BY	D4	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>11</del>	APPROVED	<del>11</del>	DRAWING NO.	REV. B
				D3319	SHEET 3 OF 5
DATE	05.06.06	TITLE	WEARPLATE		
					SCALE 1:5

05-09-30



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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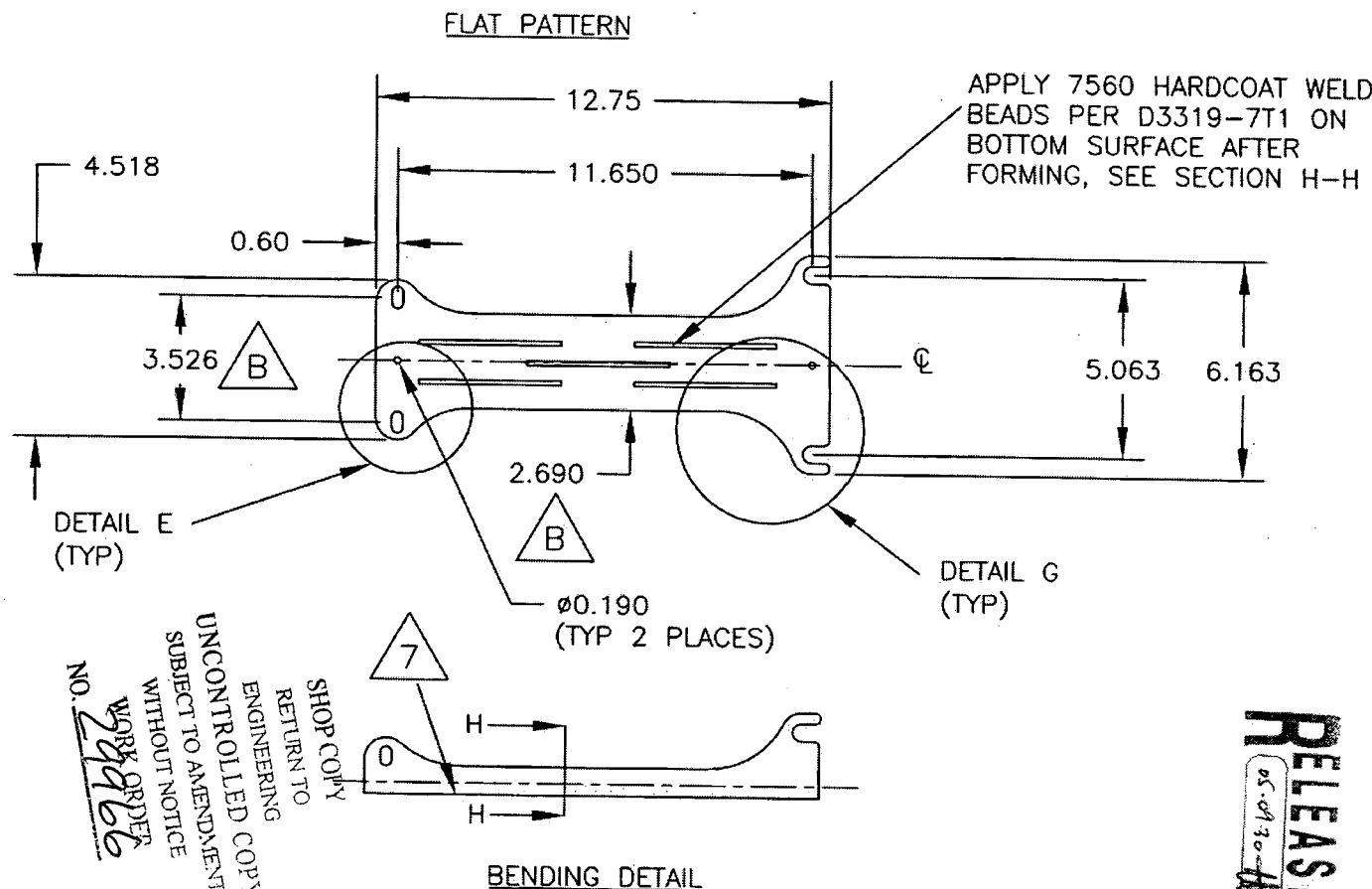
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**DART**

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CHECKED	PH	APPROVED	PH	DRAWING NO. D3319
DATE	05.06.06	TITLE	WEARPLATE	REV. B SHEET 4 OF 5
		SCALE	1:5	

**RELEASED**  
05-09-30-40



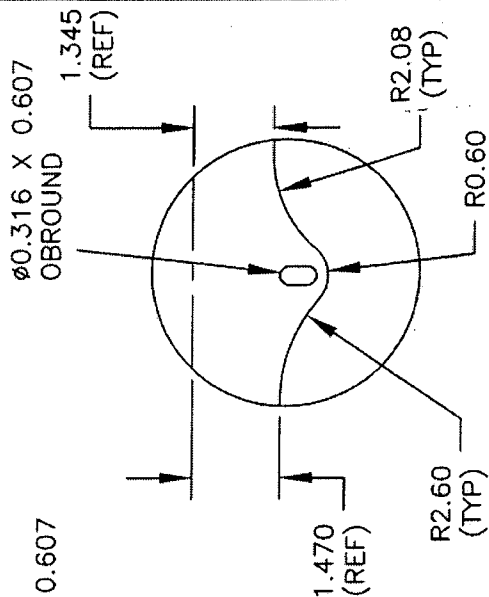
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- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

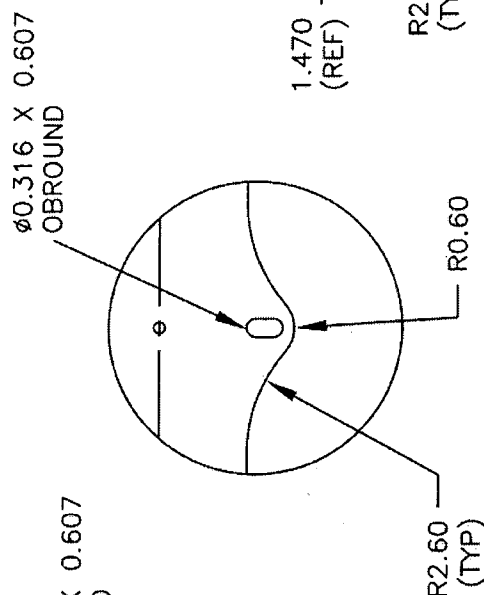


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3

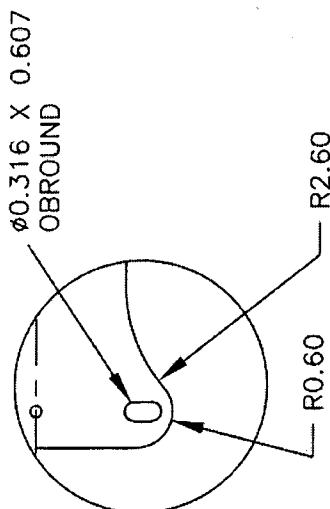
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DETAIL J

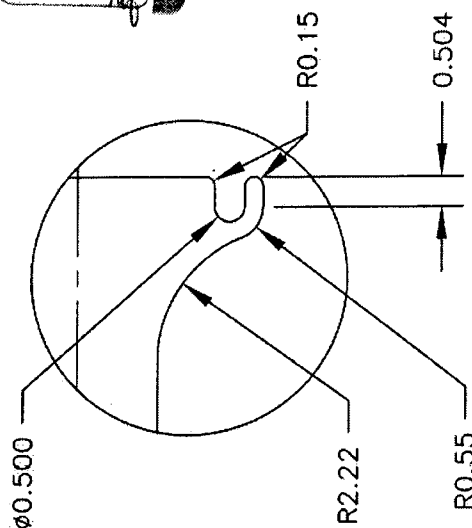


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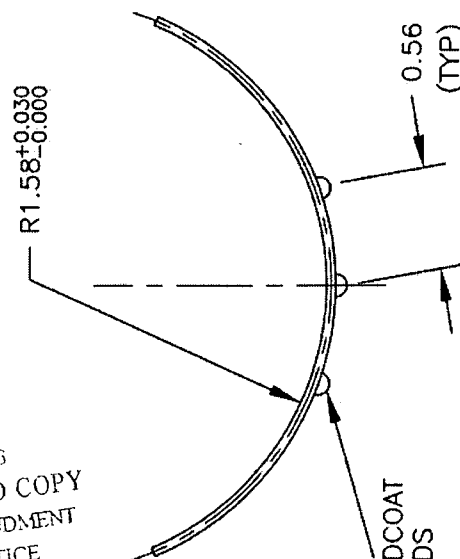


DETAIL E

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WORK ORDER  
NO. 29966



DETAIL G



SECTION H-H  
(SCALE 1:1)

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